

Date: Friday, 9/21/2007 1:19:13 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	LUG	
Job Number	34829				
Estimate Number	10008				
P.O. Number	N/A		Part Number	D2591	
This Issue	9/21/2007	S.O. No.: N/A	Drawing Number	D2591 REV D	
Prsht Rev.	NC		Project Number	N/A	
First Issue	9/21/2007	Type	MACHINED PARTS	Drawing Revision	D
Previous Run	33568		Material	N/A	
Written By			Due Date	10/5/2007	
Checked & Approved By	<i>JL 07-09-24</i>		Qty:	90 100 10 Um: Each	
Comment	Est Rev:I Removed from 9 Digit 05-10-25 JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010B0750X02500	ASTM A21 Steel .75"x2.5"  
Comment: Qty.: 0.2340 f(s)/Unit Total : 9.3600 f(s) ASTM A36 Steel bar 2.50" x 0.75" thick(M1010-B0.750X02.500) Batch: <i>M105801</i> <span style="float: right;"><i>8/8 07/10/18</i></span>		
2.0	BAND SAW	BAND SAW  
Comment: BAND SAW Cut blanks: 2.700" long <span style="float: right;"><i>8/8 07/10/18</i></span>		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1    <i>Issue 10 4830 Meter</i> <span style="float: right;"><i>C207/10/22 90</i></span>
Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio FA 039 and Dwg D2591 <i>Machine performing D2591 Read</i> 2-Deburr if required		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE  <i>Receive &amp; Inspect for transit damage</i> <span style="float: right;"><i>07/11/02 (S)</i></span>
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	QC5	SECOND CHECK    <i>Inspect level 5</i> <span style="float: right;"><i>07/11/02 (BS)</i></span>
Comment: SECOND CHECK <i>Inspect level 5</i>		
6.0	PACKAGING 1	PACKAGING RESOURCE #1    <i>Identify and Stock</i> <i>Location: Welding</i> <span style="float: right;"><i>W 07.11.05</i></span>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/11/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 34829

Part Number: D2591

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 QC21

FINAL INSPECTION/W/O RELEASE



(85)

Comment: FINAL INSPECTION/W/O RELEASE

10/11/05

Job Completion



C20 7/11/05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34829
Description: GHW Lug	Part Number:	D2591
Inspection Dwg: D2591	Rev: D	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

<b>Measured by:</b>		<b>Audited by:</b>		<b>Prototype Approval:</b>	N/A
<b>Date:</b>		<b>Date:</b>		<b>Date:</b>	N/A

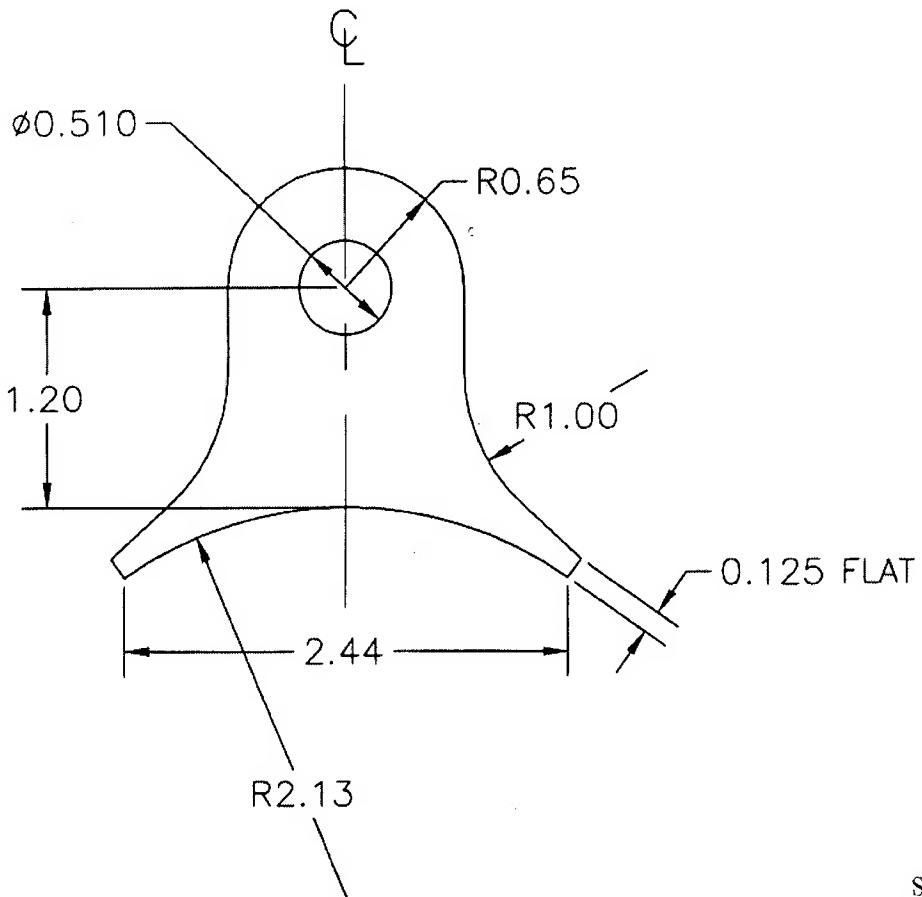
Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue P/O D205-641-011 & DS1 9161-011	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>



DA COPY  
Date

DESIGN <i>DNOY</i>	DRAWN BY <i>DNOY</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>BW</i>	DRAWING NO. D2591	REV. D SHEET 1 OF 1
DATE 98.01.21		TITLE GHW LUG	SCALE 1:1
A	96:09:16	NEW ISSUE	
B	97:06:17	RE-DESIGN TO FLAT BOTTOM	
C	97.12.12	RE-DESIGN TO RADIUS BOTTOM	
D	98.01.21	0.125 FLAT WAS 0.067 FLAT	*

RELEASED  
98.01.21 DS



BREAK ALL SHARP CORNERS ~~0.010 TO 0.020~~  
MATERIAL: ASTM A36 STEEL 0.50 THICK  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
PART IS SYMMETRIC ABOUT CENTER-LINE  
ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
No. *34829*

**CERTIFICATE OF CONFORMITY****SOLD TO:**

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

**SHIPPED TO:**

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
85	D2591	Lug B34829	4830
17	D2591	Lug B33568	4830

MATERIAL supplied by DART M1010B07540X02500 B105801

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in black ink, appearing to read "Shig Walz".

Shig Walz

Vankleek Hill, November 2, 2007



20 Terry Fox Drive  
Vankleek Hill, Ontario K0B 1R0  
Tel: (613) 678-3957  
Fax: (613) 678-3956

**Delivery Slip No.:** 16227  
**Date:** Nov 02, 2007  
**Page:** 1

Sold to:	Ship to:
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 4830	Sold By: Walz, Christian D.
Shipped By: our truck	Ship Date: Oct 31, 2007

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2591 Lug in steel B34829	Each	90		
D2591 Lug in steel B33568	Each	17	17	
Material supplied by DART M1010B07540X02500 B105801				
Please note that 5 pieces were scrapped during machining.				

Received by _____	<b>Thank you for your order!</b>
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